



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4202-1
Job Sheet 168682



Part No: D4202-1

Job Qty: 700 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/3/17

Created By: Linda Lacelle

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	700 Ea		11/30/17	0.00	0.00	Start Up Machining		
100	Hardinge	700 pcs		12/2/17	0.00	29.79	Hardinge		
120	QC	700 pcs		12/2/17	0.00	0.00	QC8		
130	Outsource	700 pcs		12/2/17			MEI001-VC		
140	Packaging	700 pcs		12/2/17	0.00	0.00	Packaging2		
150	QC	700 pcs		12/2/17	0.00	0.00	QC6		
160	HandFinish	700 pcs		12/3/17	0.00	3.50	HandFinish4		
190	Packaging	700 pcs		12/3/17	0.00	0.00	Packaging3		
200	QC21-SA	700 Ea		12/3/17	0.00	0.00	QC21		

Part Op 100 - 1- Machine as per Folio FB015 ***DO NOT CHAMFER OUTSIDE DIA***
Descriptions: 130 - ***HEAT TREAT AS PER DWG D4202***
160 - WASH SPACER AS PER QSI005
190 - ***STOCK IN SKIDTUBE CELL***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6T0.500W.058	245	214	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.500inches $\pm$ 0.010	0.510 0.490	Product	
2	Spacer	0.058inches $\pm$ 0.010	0.068 0.048	Product	
3	Spacer	4.145inches + 0.030 - 0.010	4.175 4.135	Product	

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DART
AEROSPACE
S030798

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Spacer

PART NO: D4202-1
Revision:
Operation: Packaging
Change No:

Mfg Date: 01/10/18 Job No: 168682
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PURCHASE ORDER

PURCHASE ORDER										
Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	168918	RB500N9505-1M-1	Socket 1--Issue P/O to Metcore ; P/O _____ RC 37-45 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 1--Issue P/O to Metcore ; P/O _____ RC 37-45 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech	Firmed	12/19/17	1 pcs	0 pcs	1 pcs	\$649.00/pcs	\$649.00
Line Item Note part made from 41L40										
4	168682	D4202-1	HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL	Firmed	12/19/17	700 pcs	0 pcs	700 pcs	\$0.42/pcs	\$294.00
										Grand Total: \$1,531.00

Order Notes

C2

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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
324021	1	124731

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
38630		AL-6061	2017/12/14	FEDEX

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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700 D4202-1

(700) D4202-1 JOB. 168682

1 BOITE DE CARTON

recu

601X

SP18-01-10

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

certificat

EMPAQUETAGE Packing	
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QUANTITÉ EXPÉDIÉE / Quantity Shipped : 700

POIDS EXPÉDIÉ / Weight Shipped : 19,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

certificat

QUANTITÉ EXPÉDIÉE / Quantity Shipped :	700
POIDS EXPÉDIÉ / Weight Shipped :	19,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2018/01/05

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
324021	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
38830	N/A	AL-6081		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	36 - 44 %IACS	140	37 - 39 %IACS
HARDNESS	80,5 HR15TW MIN	140	68 - 70 HR15TW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
700	19	D4202-1 (700) D4202-1 JOB. 168882 1 BOITE DE CARTON

SP 18-01-10

COMMENTAIRES / comments

8 JANU.

APPROUVÉ par / Approved by

DATE: 2018-01-05

Pierre Piché
Chief Inspector



APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
324021	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
38630	N/A	AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results				
CONDUCT	36 - 44 %IACS	140 (60 kHz)	37 - 39 %IACS	
HARDNESS	60 HR15TW MIN	140	68 - 70 HR15TW	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
700	19	D4202-1 (700) D4202-1 JOB. 168682 1 BOITE DE CARTON		

COMMENTAIRES / comments

SOL. ANNEAL 985F, 30 MIN
AGE HARDEN AMBIANT

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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Isabel Otero
QA Technician



05 JAN 2000



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D4202-1 Revision: Spacer														
120	QC	S017159	168682	99 pcs	0	S017159	MEI001-VC		WIP	12/4/2017	*			
Operation Totals:		1		99	0									
200	QC21-SA	S030798	168682	601 Ea	0	168682	LG001		Stock	1/10/2018	*			
Operation Totals:		1		601	0									
Part Totals:		2		700	0									
Part Number: M6061T6T0.500W.058 Revision: 6061-T6 Round Tube .500 X.058W														
100	Receive Ft	Fm138184.75	168682	15 ft	0	m138184	Start Up Machining		Stock	10/18/2017	*			
Operation Totals:		1		15	0									
Part Totals:		1		15	0									
Totals:		3		715	0									

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